

Work Order ID 69199

Wednesday, May 04, 2011 12:29:38 PM



Page 1

Item ID: D4368-043

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Aft Wearplate Assembly

Start Date: 5/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: AA

Date: 11.05.04 Tooling:

Date:

Stop



QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4368

PA2

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg (D4368-3)

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

B11-5-4

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00








B11-5-4



PRELIMINARY ISSUE

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Item ID:	D4368-043	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Aft Wearplate Assembly					
Start Date:	5/4/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/6/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	




Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 → Inspected only to Pa 2 Day 8/11/05/05 @							
130  Brake NC Brake NC	Form as per dwg Memo *** Jigs DT8261 and DT8326.***	0.00 SO 11/05/05				①			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 Sublog							

Fig. 1. The effect of the concentration of the solution of the initiator on the rate of polymerization of α -methylstyrene in the presence of the initiator and the catalyst. The concentration of the initiator was 0.001 mol/l. The concentration of the catalyst was 0.001 mol/l. The temperature was 50°C. The time of polymerization was 10 min. The concentration of the solution of the initiator was 0.001 mol/l. The concentration of the catalyst was 0.001 mol/l. The temperature was 50°C. The time of polymerization was 10 min.

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1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes with the original objectives and goals to determine the effectiveness of the project.

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

[illegible]

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Journal of Internal Medicine 255: 105–112

1. The first step is to identify the problem or question that needs to be answered. This involves understanding the context and the specific requirements of the task.

2. The second step is to gather relevant information and data. This can involve research, consultation with experts, or collecting data from various sources.

3. The third step is to analyze the information and data collected. This involves identifying patterns, trends, and relationships that can help in understanding the problem.

4. The fourth step is to develop a solution or answer. This involves applying the knowledge and skills gained from the previous steps to create a plan or strategy that addresses the problem.

5. The fifth step is to implement the solution. This involves putting the plan into action and monitoring the progress to ensure that the solution is effective.

6. The sixth step is to evaluate the results. This involves assessing the outcomes of the solution and determining whether they meet the requirements of the task.

7. The seventh step is to communicate the results. This involves sharing the findings and conclusions with the relevant stakeholders and providing feedback on the process.

8. The eighth step is to reflect on the process. This involves thinking about what worked well and what could be improved for future tasks.

9. The ninth step is to document the process. This involves creating a record of the steps taken and the results achieved, which can be used as a reference for future tasks.

10. The tenth step is to review the process. This involves looking back at the entire process and identifying any areas for improvement or further research.

[illegible]

**Insp.
Stamp**

[illegible][illegible]

Quality Control






X1 11-06-08 E/JBL

PL 11.06.05



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Item ID:	D4368-043	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Aft Wearplate Assembly					
Start Date:	5/4/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/6/2011	Req'd Qty:	1.00		Customer:	

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	Inspector to P42 By only Subactor @						
180  Small Fab Small Fab	1- After finish, coat entire top (concave) surface as per note 10 on sheet 2 dwg D4368. Black Rockguard Plus 1 M116210	0.00 0.00							M 11 06 09 (1)
190  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

Picklist Print

Page 1

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Work Order ID: 69199



Parent Item: D4368-043



Parent Item Name: Aft Wearplate Assembly

Start Date: 5/4/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4369-3

Manufactured

No

150

Each

1.0000

1

1



11-6-82/BL

Bar

Location

Loc Qty

Loc Code

FG

1

68406

1

X1

M304S18GA

Purchased

No

100

sf

129.0000

2.179

2.293684



B 11-5-4

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

129

112178

4

113062

18

116135

26

116604

12

116979

69

116604

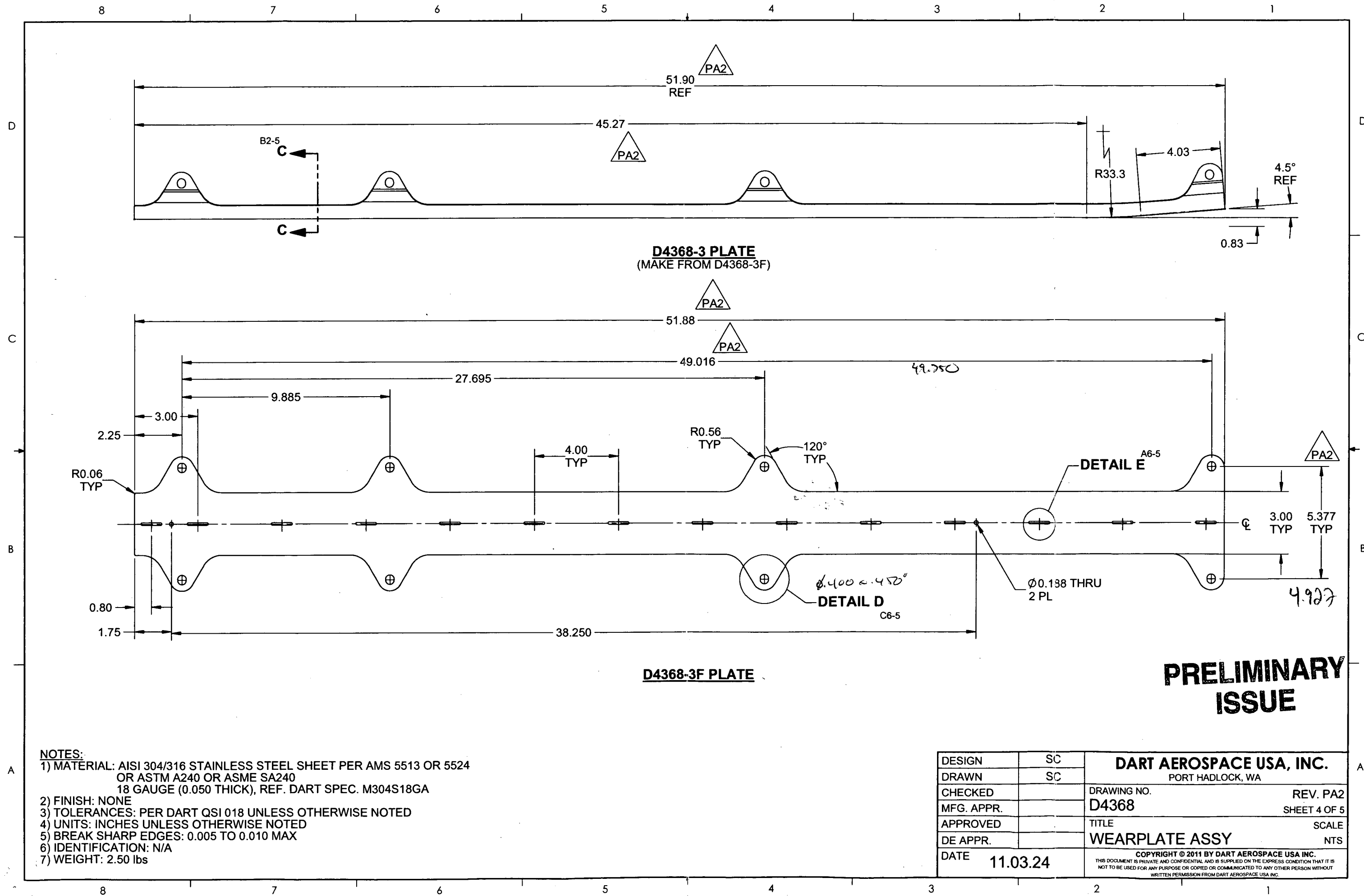
DART AEROSPACE LTD		Work Order: 69199
Description: AFT WEAR PLATE ASSEMBLY		Part Number: D4368-042
Inspection Dwg: D4368-3, Rev: PA2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.400	$\pm .010$.401	✓		V RB02	
.050	$\pm .010$.050	✓		V	
.875	$\pm .010$.875	✓		V	
.125	$\pm .010$.127	✓		V	
Ø .188	$\pm .005 - .001$.190	✓		V	
3.00	$\pm .030$	3.009	✓		V	
5.371	$\pm .010$	5.377	✓		V	
4.00	$\pm .030$	4.001	✓		V	
.80	$\pm .030$.800	✓		V	
1.75	$\pm .030$	1.754	✓		V	
2.25	$\pm .030$	2.253	✓		V	
3.00	$\pm .030$	3.000	✓		V	
9.885	$\pm .010$	9.885	✓		T RB02	
27.695	$\pm .010$	27.695	✓		T	
49.016	$\pm .010$	49.016	✓		T	
51.88	$\pm .030$	51.88	✓		T	
1050	$\pm .010$	1050	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:
Date: 11-5-4	Date: 11/15/05 TO PA2 en by	Date:
Rev A	Date	Change
		New Issue
Revised by: KJ/JLM	Approved:	



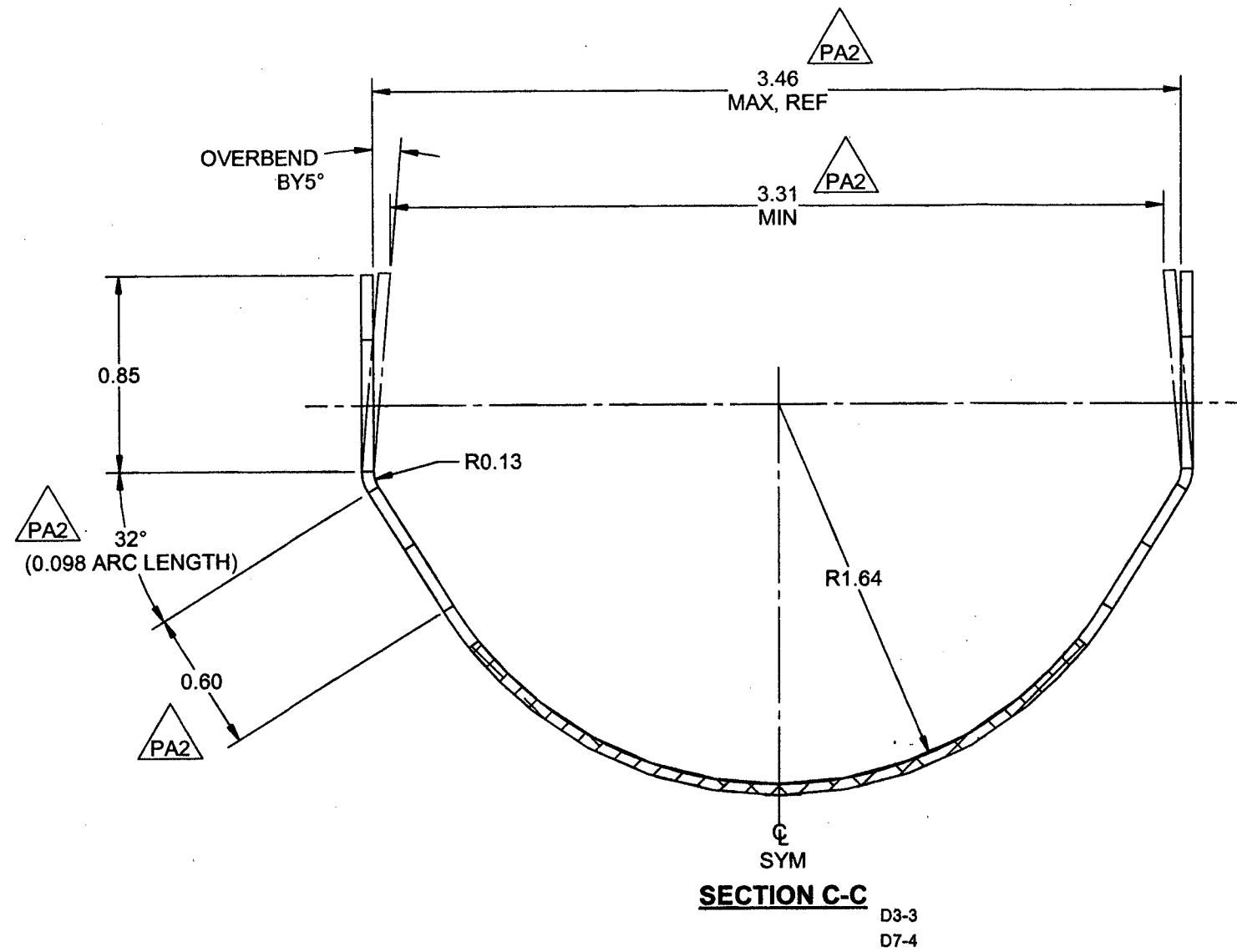
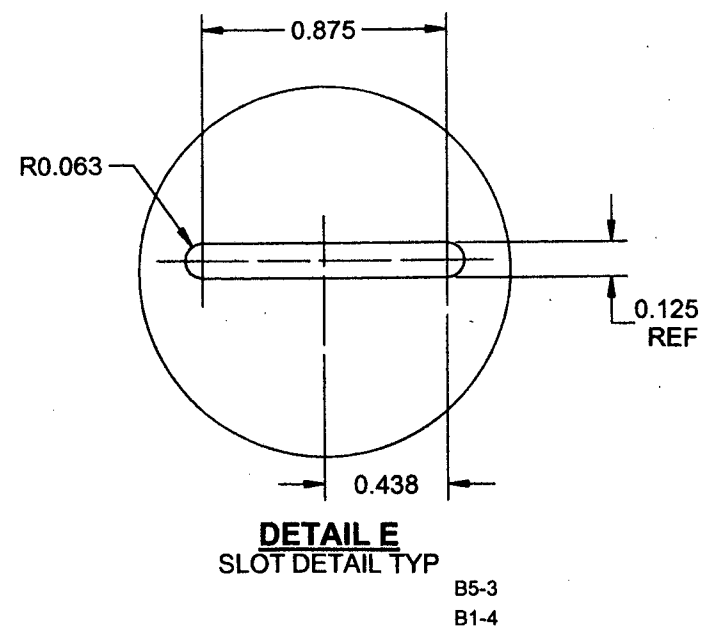
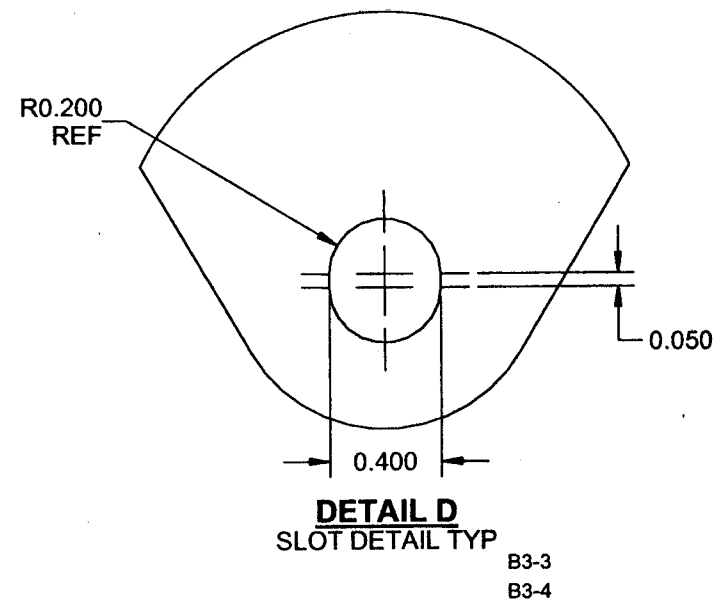
D4368-3 PLATE
(MAKE FROM D4368-3F)

D4368-3F PLATE

PRELIMINARY
ISSUE

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.50 lbs

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4368	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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